

duplicate

Work Order ID 99510

99510

Page 1

July-25-13 7:44:40 AM

Item ID: D139-799-013

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cargo Door Fwd Opening Fits LH Or RH

Start Date: 4/10/13 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 4/24/13 Req'd Qty: 4.00 *4*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D139-799

G

100

0.00

100

DC

Document Control

Memo M.D.

Photocopy bluefile & type labels per PPP D139-799-013
CHG006

0.00

13819

4x

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

4x

13/8/19
M.D. 13-07-30

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Quality Control

Memo

0.00

13819

4

Work Order ID 99510***99510***

Page 2

July-25-13 7:44:40 AM

Item ID: D139-799-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cargo Door Fwd Opening Fits LH Or RH

Start Date: 4/10/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/24/13 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D139-799-013								
	Location: 023								
	PPP rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLJ 13-08-21MLJ 13-08-20

Picklist Print

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Page 1

Work Order ID: 99510

Parent Item: D139-799-013

Parent Item Name: Cargo Door Fwd Opening Fits LH Or RH

Start Date: 4/10/13

Required Date: 4/24/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.06.08 new issue DD verf:JLM
 11-06-05 JLM VERIFIED BY:DD
 IPP REV:C AS PER DSI9567 revA 11.10.17 DD VERF:EC
 ccn 12-507 DD verf:EC IPP REV:E 12.06.14 per ccn 12-606 DD verf:EC
 REV:F 13.02.19 PER ECN13-507 DD verf:JLM
 IPP REV:B AS PER ECN 11-598
 IPP REV:D 12.01.19 per iin rev.f
 IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4632-1 STRIKER PLATE		Manufactured	No			110	Each	4.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		2							
				97450		2							
				ST116		2							
				97450		2							
D4632-2 STRIKER PLATE		Manufactured	No			110	Each	4.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		2							
				97451		2							
				ST116		2							
				97451		2							
MS21042L08 Nut		Purchased	No			110	Each	3,397.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST315		1397							
				122141		3							
				122452		9							
				122814		500							
				123900		885							
				ST505		2000							
				125445		2000							

SRB 4x

SRB 4x

SRB

B100986 (2x)

B100735 (2x)

32x

11.10.13-07-31

11.10.13

11.10.13

Picklist Print

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Page 2

Work Order ID: 99510

Parent Item: D139-799-013

Parent Item Name: Cargo Door Fwd Opening Fits LH Or RH

Start Date: 4/10/13

Required Date: 4/24/13

Start Qty: 4.00

Required Qty: 4.00

MS24694-S47
SCREW

Purchased No

110 Each 180.0000

8 32

11.10.13-07-31

Location

Loc Qty

Loc Code

ST303

180

115622

8

122594

4

124684

168

32x

MS27039-08-07
SCREW

Purchased No

110 Each 277.0000

8 32

11.10.13-07-31

Location

Loc Qty

Loc Code

ST307

277

122563

277

32x

NAS1149D0332J
Washer

Purchased No

110 Each 3,005.0000

16 64

11.10.13-07-31

Location

Loc Qty

Loc Code

ST293

37

125268

37

ST294

2968

122973

68

125044

284

m125807

2616

64x

NAS1149DN832J
Washer

Purchased No

110 Each 5,485.0000

8 32

11.10.13-07-31

Location

Loc Qty

Loc Code

ST293

1485

123603

87

124555

398

M126221

1000

ST510a

4000

M126319

4000

32x

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Shop Packet Print

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Picklist Print

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Page 3

Work Order ID: 99510

Parent Item: D139-799-013

Parent Item Name: Cargo Door Fwd Opening Fits LH Or RH

Start Date: 4/10/13

Required Date: 4/24/13

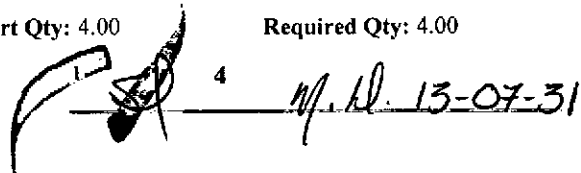
Start Qty: 4.00

Required Qty: 4.00

D2585
Latch Clamp

Manufactured No

110 Each 56.0000



Location

Loc Qty

Loc Code

ST012

56

100527

26

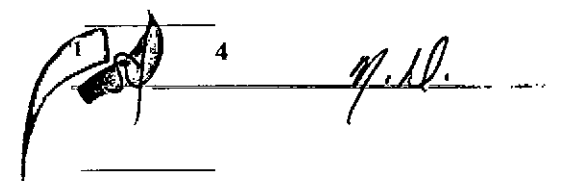
101805

25

99063

5

110 Each 112.0000



Location

Loc Qty

Loc Code

FG

11

83893

10

95760

1

return2013

3

xxxxxx

3

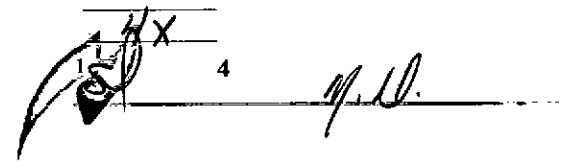
ST203A

98

100607

98

110 Each 30.0000



Location

Loc Qty

Loc Code

FG

2

88616

2

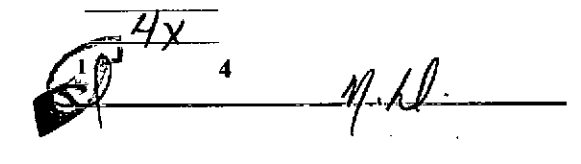
ST014

28

88616

28

110 Each 19.0000



Location

Loc Qty

Loc Code

FG

5

83586

2

91743

3

ST261


14

101060

10

91743

4



D2621
Latch Plate

Manufactured No

110 Each 30.0000

D3552-23
Door Prop

Manufactured No

110 Each 19.0000

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Page 4

Work Order ID: 99510

Parent Item: D139-799-013

Parent Item Name: Cargo Door Fwd Opening Fits LH Or RH

Start Date: 4/10/13

Required Date: 4/24/13

Start Qty: 4.00

Required Qty: 4.00

D3622-1
Ball Stud

Manufactured No

Location

ST060

102228

95919

99796

110 Each 47.0000

Loc Qty

Loc Code

47

20

24

3

110 Each 19.0000

Loc Qty

Loc Code

19

2

17

110 Each 13.0000

Loc Qty

Loc Code

13

4

9

110 Each 8.0000

Loc Qty

Loc Code

8

8

110 Each 38.0000

Loc Qty

Loc Code

4

4

34

24

10

D3622-3
Ball Stud

Manufactured No

Location

ST060

52939

88383

110 Each 19.0000

Loc Qty

Loc Code

19

2

17

110 Each 13.0000

Loc Qty

Loc Code

13

4

9

110 Each 8.0000

Loc Qty

Loc Code

8

8

110 Each 38.0000

Loc Qty

Loc Code

4

4

34

24

10

D4072-1
AIRFRAME HINGE

Manufactured No

Location

ST091

86204

99843

110 Each 13.0000

Loc Qty

Loc Code

13

4

9

110 Each 8.0000

Loc Qty

Loc Code

8

8

110 Each 38.0000

Loc Qty

Loc Code

4

4

34

24

10

D4072-3
Airframe Hinge Backing Plate

Manufactured No

Location

ST091

82837

110 Each 8.0000

Loc Qty

Loc Code

8

8

110 Each 38.0000

Loc Qty

Loc Code

4

4

34

24

10

D4072-5
BUSHING

Manufactured No

Location

FG

98569

ST091

103525

98569

110 Each 38.0000

Loc Qty

Loc Code

4

4

34

24

10

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Picklist Print

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Page 5

Work Order ID: 99510

Parent Item: D139-799-013

Parent Item Name: Cargo Door Fwd Opening Fits LH Or RH

Start Date: 4/10/13

Required Date: 4/24/13

Start Qty: 4.00

Required Qty: 4.00

D4073-1
DOOR HINGE

Manufactured No

110 Each 8.0000

2  8 7.10.13-07-30

Shp 40

Location

Loc Qty

Loc Code

ST091

8

99521

8

D4073-3

Door Hinge Backing Plate

Manufactured No

110 Each 11.0000

2 8x 8 7.10.13 

Shp 40

Location

Loc Qty

Loc Code

ST091

11

78527

1

89046


10

D4074-1

Bracket

Manufactured No

110 Each 8.0000

1 8x 4 7.10.13 

Shp 40

Location

Loc Qty

Loc Code

ST091

8

86205


8

D4074-3

Channel

Manufactured No

110 Each 15.0000

1 4x 4 7.10.13 

Shp 40

Location

Loc Qty

Loc Code

ST091

15

80696

3

89042


12

D4074-5

Backing Plate

Manufactured No

110 Each 72.0000

1 3x 1x 4 7.10.13 

Shp 40

Location

Loc Qty

Loc Code

ST092

72

74495

70

76339

2

4x

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Picklist Print

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Page 6

Work Order ID: 99510

Parent Item: D139-799-013

Parent Item Name: Cargo Door Fwd Opening Fits LH Or RH

Start Date: 4/10/13

Required Date: 4/24/13

Start Qty: 4.00

Required Qty: 4.00

D4074-7
Striker Plate

Manufactured No

110 Each 6.0000

Handwritten: 1 ~~4~~ 4 11.10.13-07-30

Location

Loc Qty

Loc Code

FG
89406
ST092
89406

2
2
4
4

Blank lines for location codes

D4519-1
RELAY BRACKET

Manufactured No

110 Each 25.0000

Handwritten: 4x ~~4~~ 4 11.11.

Location

Loc Qty

Loc Code

ST
89041
99522
ST111
102694
99522

10
3
7
15
10
5

Blank lines for location codes
4x

Picklist Print

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Page 7

Work Order ID: 99510

Parent Item: D139-799-013

Parent Item Name: Cargo Door Fwd Opning Fits LH Or RH

Start Date: 4/10/13

Required Date: 4/24/13

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Nut

Purchased No

110

Each

7,744.0000

144

M.D. 13-07-30

Location

Loc Qty

Loc Code

FP001

3

122141

3

GA

18

122452

18

ST314

1235

111668

1

117885

32

119017

55

119075

138

123265

43

M126036

966

144X

ST506

1488

123900

912

124291

576

ST510a

5000

M126275

1000

M126333

4000

MS21042L5

Nut

Purchased No

110

Each

1,555.0000

4

M.D.

Location

Loc Qty

Loc Code

ST314

574

125654

574

4X

ST506

1

123900

1

st507

980

125535

980

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Page 8

Work Order ID: 99510

Parent Item: D139-799-013

Parent Item Name: Cargo Door Fwd Opening Fits LH Or RH

Start Date: 4/10/13

Required Date: 4/24/13

Start Qty: 4.00

Required Qty: 4.00

MS27039-1-10
SCREW

Purchased No

110 Each 441.0000



32

7.10.13-07-30

Location

Loc Qty

Loc Code

GA
120449
ST305
122815
124859
125654
ST308
123522
ST506
124326

100
100
301
1
100
200
18
18
22
22

20X

12X

MS27039-1-14
Screw

Purchased No

110 Each 1,143.0000



8

7.10.13-07-30

Location

Loc Qty

Loc Code

GA
120449
ST305
112312
120177
ST506
124326

100
100
43
17
26
1000
1000

7X

1X

MS27039-1-16
Screw

Purchased No

110 Each 228.0000



32

7.10.13-07-30

Location

Loc Qty

Loc Code

ST306
122993
125654

228
28
200

32X

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Shop Packet Print

Page 8

Picklist Print

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Page 9

Work Order ID: 99510

Parent Item: D139-799-013

Parent Item Name: Cargo Door Fwd Opening Fits LH Or RH

Start Date: 4/10/13

Required Date: 4/24/13

Start Qty: 4.00

Required Qty: 4.00

MS27039-1-17
Screw (601.1954)

Purchased No

110 Each 216.0000

4

17.11.13-07-30

Shs 40

Location

Loc Qty

Loc Code

GA 48
120142 48
ST506 168
124326 168

110 Each 8,496.0000

18

72

NAS1149D0363J
Washer

Purchased No

Shs 10

Location

Loc Qty

Loc Code

FP001 1
123248 1
ST294 995
113068 11
122378 21
124392 963
ST510a 7500
m126319 7500

110 Each 3,135.0000

4

NAS1149D0663J
Washer

Purchased No

Shs 4X

Location

Loc Qty

Loc Code

ST294 2436
123265 1 2
123900 1
124670 19
M125709 5
M125807 108
M126284 2301
ST510a 699
M126334 699

4X

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Page 10

Work Order ID: 99510

Parent Item: D139-799-013

Parent Item Name: Cargo Door Fwd Opening Fits LH Or RH

NAS1515H5L

Washer

Purchased No

110 Each

Start Date: 4/10/13

Required Date: 4/24/13

Start Qty: 4.00

Required Qty: 4.00

464.0000

16

M.D. 13-07-30

SMS TA

Location

Loc Qty

Loc Code

FG
103691
ST297
124859
125621

40
40
424
22
402

Purchased No

110 Each

22.0000

16x
4
M.D.

IN4007

DIODE

SMS TA

Location

Loc Qty

Loc Code

FG
120363
ST284
120363

16
10
12
12

Purchased No

110 Each

31.0000

2x
4
M.D.

M12883/41-19

RELAY BASE

SMS TA

Location

Loc Qty

Loc Code

FG
122097
125289
ST511
125289

16
1
15
15
15

Purchased No

110 Each

124.0000

4x
4
16
M.D.

M39029/92-534

SOCKET CONTACT

SMS TA

Location

Loc Qty

Loc Code

FG
120363
125289
ST511
120344
120363

70
20
50
54
33
21

16x

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Work Order ID: 99510

Parent Item: D139-799-013

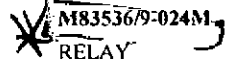
Parent Item Name: Cargo Door Fwd Opening Fits LH Or RH

Start Date: 4/10/13

Required Date: 4/24/13

Start Qty: 4.00

Required Qty: 4.00

 M83536/9-024M
RELAY

Purchased No

Location

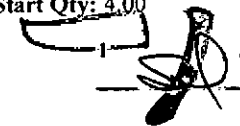
FG
124916
ST390
122097

110 Each 21.0000

Loc Qty

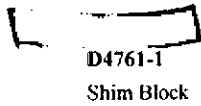
20
20
1
1

Loc Code

 4 M.D. 13-07-30

SHS UP

4x

 D4761-1
Shim Block

Manufactured No

Location

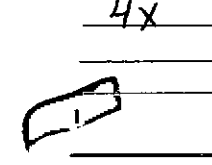
ST122
97446

110 Each 14.0000

Loc Qty

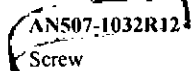
14
14

Loc Code

 4 M.D. SD

SHS UP

4x

 AN507-1032R12
Screw

MS24693-S274

Purchased No

Location

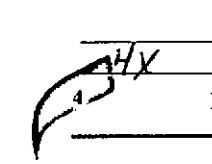
ST343
m125709

110 Each 100.0000

Loc Qty

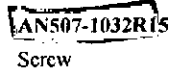
100
100

Loc Code

 4 16x M.D. SD

SHS UP

16x

 AN507-1032R15
Screw

Purchased No

Location

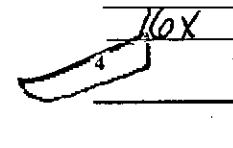
ST343
124703

110 Each 76.0000

Loc Qty

76
76

Loc Code

 4 16x M.D. SD

SHS UP

16x

Qty. -013	Part Number	Description
X	D139-799-013	CARGO DOOR HINGE KIT
1	D2585	MOUNTING CHANNEL
1	D2586	DOOR LATCH
1	D2624	LATCH PLATE
1	D3552-23	DOOR PROP
1	D3622-1L	BALL STUD
1	D3622-3	BALL STUD
2	D4072-1	AIRFRAME HINGE
2	D4072-3	AIRFRAME HINGE BACKING PLATE
4	D4072-5	BUSHING
2	D4073-1	DOOR HINGE
2	D4073-3	DOOR HINGE BACKING PLATE
1	D4074-1	BRACKET
1	D4074-3	CHANNEL
1	D4074-5	BACKING PLATE
1	D4074-7	STRIKER PLATE
1	D4519-1	RELAY BRACKET
1	D4632-1L	STRIKER PLATE
1	D4632-2	STRIKER PLATE
1	IN4007	DIODE
1	M12883-41-19	RELAY BASE
4	M39029/92-534	SOCKET CONTACT
1	M83536/9-024M	RELAY
8	MS21042L08	NUT (or MS21042-08)
28	MS21042L3	NUT (or MS21042-3)
1	MS21042L5	NUT (or MS21042-5)
8	MS24694-S47	SCREW
8	MS27039-0807	SCREW
8	MS27039-1-10	SCREW
2	MS27039-1-14	SCREW
8	MS27039-1-16	SCREW
1	MS27039-1-17	SCREW
18	NAS1149D0363J	WASHER (or AN960JD10)
1	NAS1149D0663J	WASHER (or AN960JD616)
8	NAS1149D0332J	WASHER (or AN960JD10L)
18	NAS1149DN832J	WASHER (or AN960JD8)
4	NAS1515H-5L	WASHER

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Revision: G

Date: 12.09.18

REFERENCE ONLY
DART SERVICE INSTRUCTION
 TO AMEND IIN-D139-799 REV. G AND ICA-D139-799 REV. 6
 REF. FAA STC: SR02138SE
 REF. EASA STC: 10038656

PURPOSE

Agusta AW139 aircraft with 3G5230A02431/3G5230A02531 cargo door hinges installed may require the installation of an additional shim when installing the D4631-1/-2 Striker plates as part of the D139-799-013 Cargo Door Fwd Opening Kit per Section 3.2.2.10 of IIN-D139-799. The purpose of this Dart DSI is to provide the necessary hardware and instructions for the installation of the shim.

PROCEDURE

1. After removing the existing door hinges and the existing 3G5230A02651 shim, position the D4761-1 shim block against the airframe on the inside of the door in the same location as the removed 3G5230A02651 shim as shown in Figure 1 and transfer drill 4x Ø0.201 holes from the airframe to the shim block.
2. Position the D4632-1/-2 striker plate, centered between the newly drilled holes so that it will align with the D2586 latch.
3. Mark the position of the D4632-1/-2 striker plate on the D4761-1 shim block.
4. Remove the D4632-1/-2 striker plate and D4761-1 shim block from the aircraft and drill and countersink 4x Ø0.201 holes as shown in Figure 2.
5. Deburr and touch up holes with MIL-P-85582 or MIL-P23377 primer.
6. Install D4632-1/-2 striker plate onto D4761-1 shim block using AN507-1032R12 screws, NAS1149D0332J washers and MS21042L3 nuts.
7. Install shim block striker plate assembly onto aircraft using AN507-1032R15 screws, NAS1149D0332J washers and MS21042L3 nuts.
8. Complete the D139-799-013 installation per Sections 3.2.2.11 thru 3.2.2.16 of IIN-139-799.

PART LIST

Note: For customers who already have D139-799-013 at CHG 005 and earlier, procure the DSI 9641-011 kit from Dart. Each DSI 9641-011 Kit provides parts to retrofit 1 x D139-799-013 Kit. These parts have been added to D139-799-013 @ CHG 006 and subsequent.

QTY. -011	PART NUMBER	DESCRIPTION
X	DSI 9641-011	CARGO DOOR SHIM MOD KIT
1	D4761-1J	SHIM BLOCK
4	AN507-1032R12	SCREW
4	AN507-1032R15	SCREW
8	NAS1149D0332J	WASHER
8	MS21042L3	NUT

WEIGHT & BALANCE

This DSI has a negligible effect on Weight & Balance

A	NEW ISSUE	RF	13.01.08
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9641	SHEET 1 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CARGO DOOR SHIM MOD	NTS
DATE	13.01.08	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Work Order ID 99510

July-25-13 7:44:40 AM

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99510

Page 1

Item ID: D139-799-013

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cargo Door Fwd Opening Fits LH Or RH

Start Date: 4/10/13 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 4/24/13 Req'd Qty: 4.00 *4*

Customer:

Reference:

Approvals: Process Plan: *[Signature]* Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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IIN-D139-799	G
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100		0.00							
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100

DC

Document Control

Memo *M.D.*
Photocopy bluefile & type labels per PPP D139-799-013
CHG006

0.00

MW 13-07-30
4x *[Signature]*

110	Pick Kit	0.00							
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110

Packaging

Packaging

Memo

0.00

4x *M.D. 13-07-30*

120	QC4- 100% Inspect kits for completeness	0.00							
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120

QC

Quality Control

Memo

0.00

